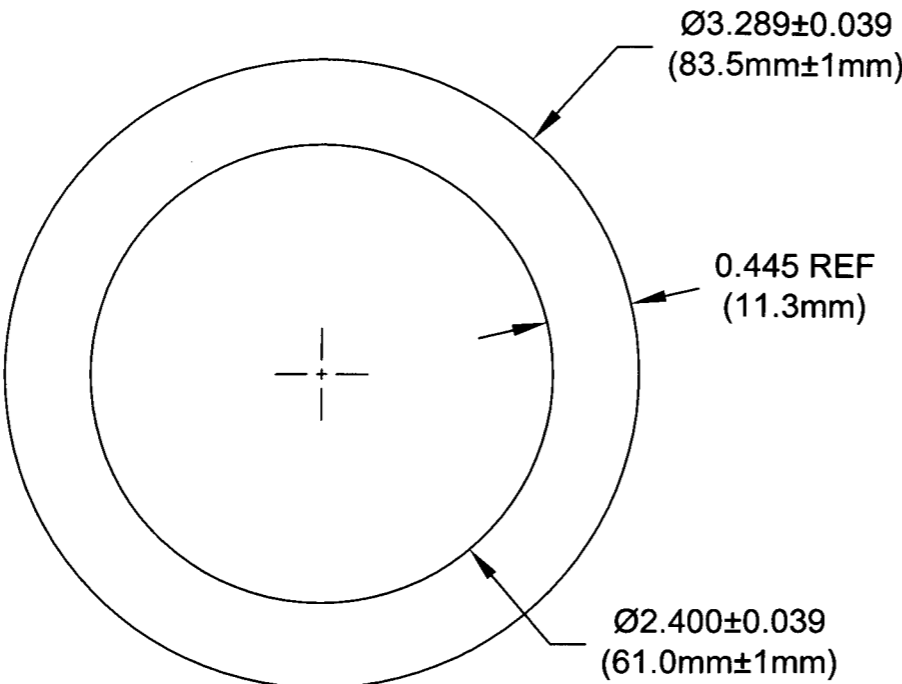


SPECIFICATION CONTROL DRAWING



NOTES

1) D6020-XXX CROSSTUBE
LENGTH

WHERE XXX IS LENGTH IN INCHES
EG. 160" LONG TUBE: D6020-160

2) MATERIAL: 17-4PH SEAMLESS STAINLESS STEEL TUBE PER ASTM A564
 $\text{Ø}3.289$ O.D. x $\text{Ø}2.400$ I.D.

HEAT TREAT TO H1025 CONDITION (HRc 34-42):
MIN. ULTIMATE TENSILE STRENGTH = 155 ksi
MIN. YIELD TENSILE STRENGTH = 145 ksi

3) TOLERANCES ARE AS FOLLOWS:
ECCENTRICITY: 15% (+/-0.066" WALL)
LENGTH: XXX +0.188"/-0.000"
STRAIGHTNESS: 0.012" DEVIATION / 12" LENGTH

4) ALL DIMENSIONS ARE IN INCHES
5) TUBE MUST BE PICKLED OR ELECTROPOLISHED TO BE SMOOTH AND FREE FROM SCALE.
6) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.

RELEASED
2013-08-14

A	NEW ISSUE		CP	13.04.24
REV.	DESCRIPTION		BY	DATE
DESIGN	qp	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN	qp			
CHECKED	A.P.	DRAWING NO.	REV. A	
MFG. APPR.	W.D.	D6020	SHEET 1 OF 1	
APPROVED	W.D.	TITLE	SCALE	
DE APPR.	W.D.	CROSSTUBE MATERIAL	NTS	
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